

Date: Friday, 01/08/2008 1:15:26 PM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 40933		
Estimate Number	: 10694		
P.O. Number	:	Part Number	: D34545
This Issue	: 01/08/2008 S.O. No. :	Drawing Number	: D3454 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 01/08/2008 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 34842	Material	:
Written By	: <u>Jud/08.08.01</u>	Due Date	: 08/08/2008 Qty: 30 Um: Each
Checked & Approved By	:		
Comment	: EST REV. A 05.11.17 New Issue EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M303R0750 303 Round Bar 0.750



Comment: Qty.: 0.0394 f(s)/Unit Total : 1.1813 f(s)

303 Round Bar .75"

(M303R0750)

Batch: 108230mm= 08/08/02

(31)

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-TURN AS PER FOLIO FA572 & DWG D3454,

FOLIO REV: AADWG REV: B

2-DEBURR AS REQUIRED

mm= 08/08/02

(31)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

mm= 08/08/02

(31)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

mm= 08/08/02

(31)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE

Deburr if necessary.

mm= 08/08/0208/08/21

(31)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 40933

Part Number: D34545

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counted
(830)

5 08/08/21

Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

6 08.08/21 31

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/22

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-08-21

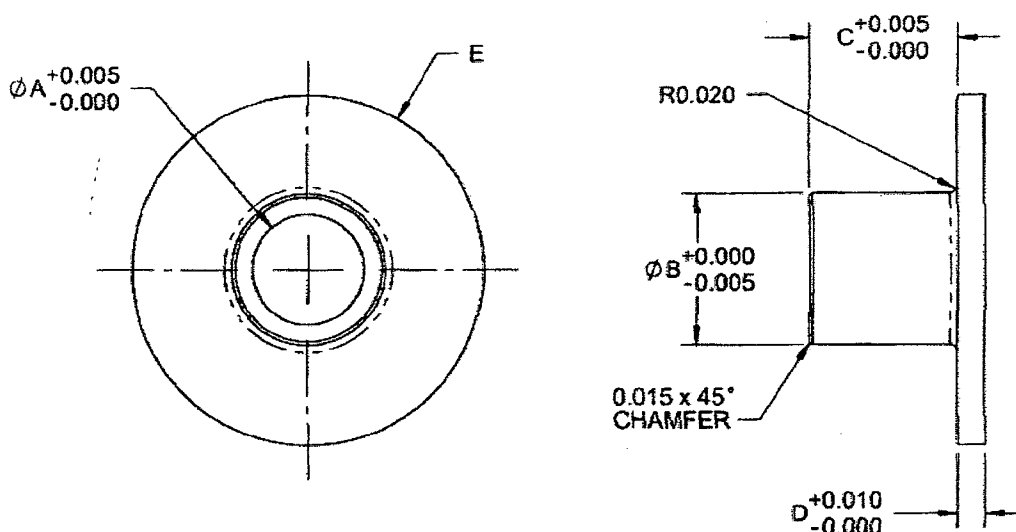


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3454	REV. B SHEET 1 OF 1
DATE 05.12.05		TITLE BUSHING	SCALE 2:1
A	05.09.02	NEW ISSUE	
B	05.12.05	REVISE -5/-7	

RELEASED

05.12.05 *[Signature]*

W/o 40933



D3454-X

1) SPECIFICATION: D3454-X BUSHING

DASH No.

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH No.	A (in)	B (in)	C (in)	D (in)	E (in)
-1	0.316	0.435	0.420	0.060	1.00
-3	0.316	0.435	0.400	0.060	0.75
-5	0.250	0.372	0.400	0.060	0.75
-7	0.250	0.372	0.343	0.060	0.75



NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) IDENTIFY WITH P/N USING FINE POINT PERMANENT MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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